

Work Order ID 162841

Friday, June 16, 2017 7:26:17 AM

162841

Page 2

Item ID: D3278-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 6/16/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 6/29/2017 Req'd Qty: 40.00 ***40*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.80				40	Ø		45 9-89 2017-8-2
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.69				40	Ø		2017-08-03 JSL BEB.
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:15 FINISH TIME: 3:45	0.00 0.49				40	Ø	1708-3	1708-3

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Item ID: D3278-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 6/16/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 6/29/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						40			
QC	Memo	0.40							
Quality Control									AUG 04 2017
170	Identify as per dwg & Stock Location: _____	0.00							DAS 26 9-89
170						40X			
Packaging	Memo	0.40							AUG 08 2017
Packaging	LOCATION : GA								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	4.00							
Quality Control									17/8/10 JF

AUG 08 2017

Picklist Print

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Parent Item: D3278-1

D3278-1

Parent Item Name: Support

Start Date: 6/16/2017

Required Date: 6/29/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	26.0950	0.2337	9.84			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

**

L.A. 17-06-19

Location	Loc Qty	Loc Code
MAT	26.095	
M136882	2.095	
M137481	12	
➔ M137586	12	

8.750ft

M137980 ➔ 1.00

DART AEROSPACE LTD		Work Order:	162841
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	—		G-pin	
0.359	+/-0.005	.362	—		Vern HL-08	
0.609	+/-0.010	.662	—		"	
0.250	+/-0.010	.250	—		"	
1.480	+/-0.005	1.480	—		"	
R0.125	+/-0.010	R.125	—		R-G	
0.119	+0.005/-0.004	.120	—		Vern HL-08	
2.439	+/-0.010	2.439	—		"	
1.980	+/-0.010	1.981	—		"	
R0.13	+/-0.030	R.125	—		R-G	
Ø0.257	+0.005/-0.000	Ø.257	—		Vern HL-08	
R0.375	+/-0.010	R.375	—		R-G	
0.875	+/-0.010	.875	—		Vern HL-08	
0.500	+/-0.010	.500	—		"	
R0.400	+/-0.010	R.400	—		"	
R1.00	+/-0.030	R1.000	—		"	
1.720	+/-0.010	1.722	—		"	
R0.125	+/-0.010	R.125	—		R-G	
0.125	+/-0.010	.127	—		Vern HL-08	

Measured by: DAS 14 9-89		Audited by: DAS 45 9-89		Prototype Approval: N/A	
Date: 17/08/02		Date: 20/7-8-2		Date: N/A	

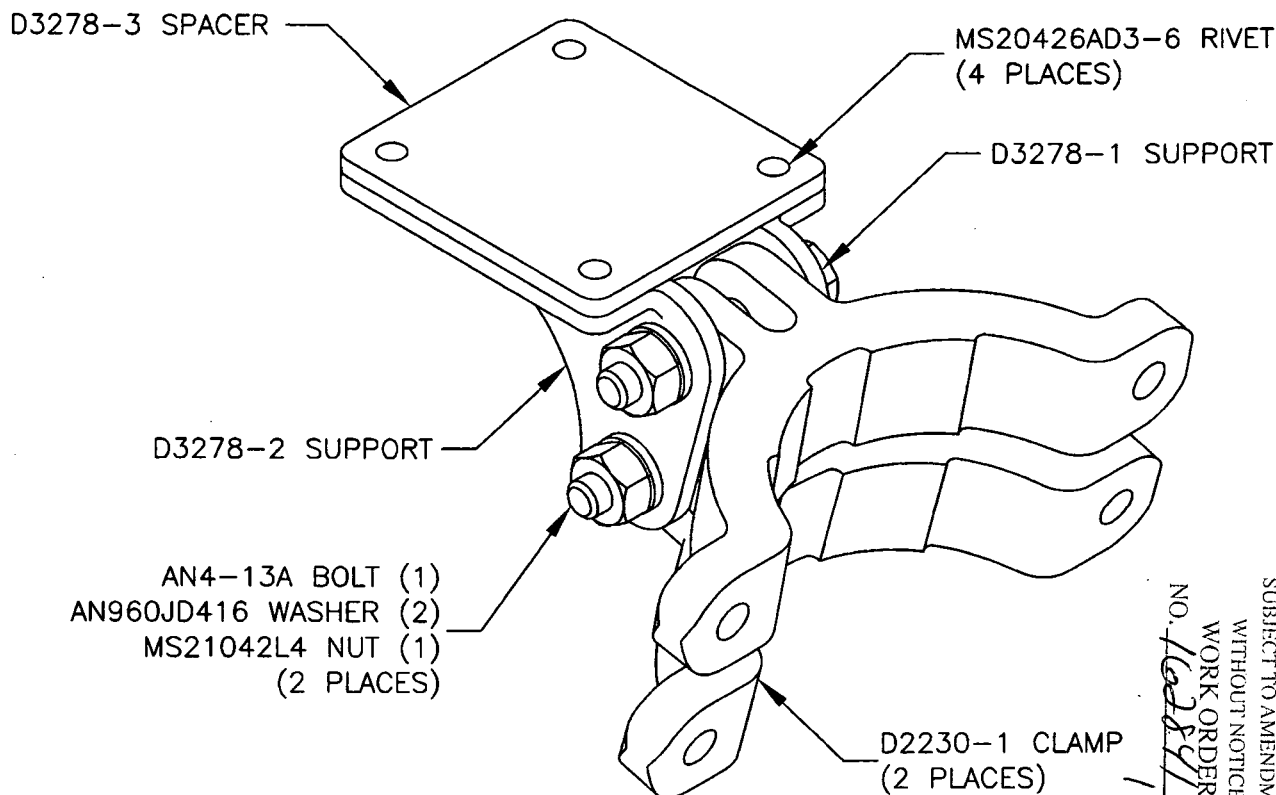
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	



DESIGN <i>90</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-18

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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WORK ORDER
NO. 162841/MS
1706-19

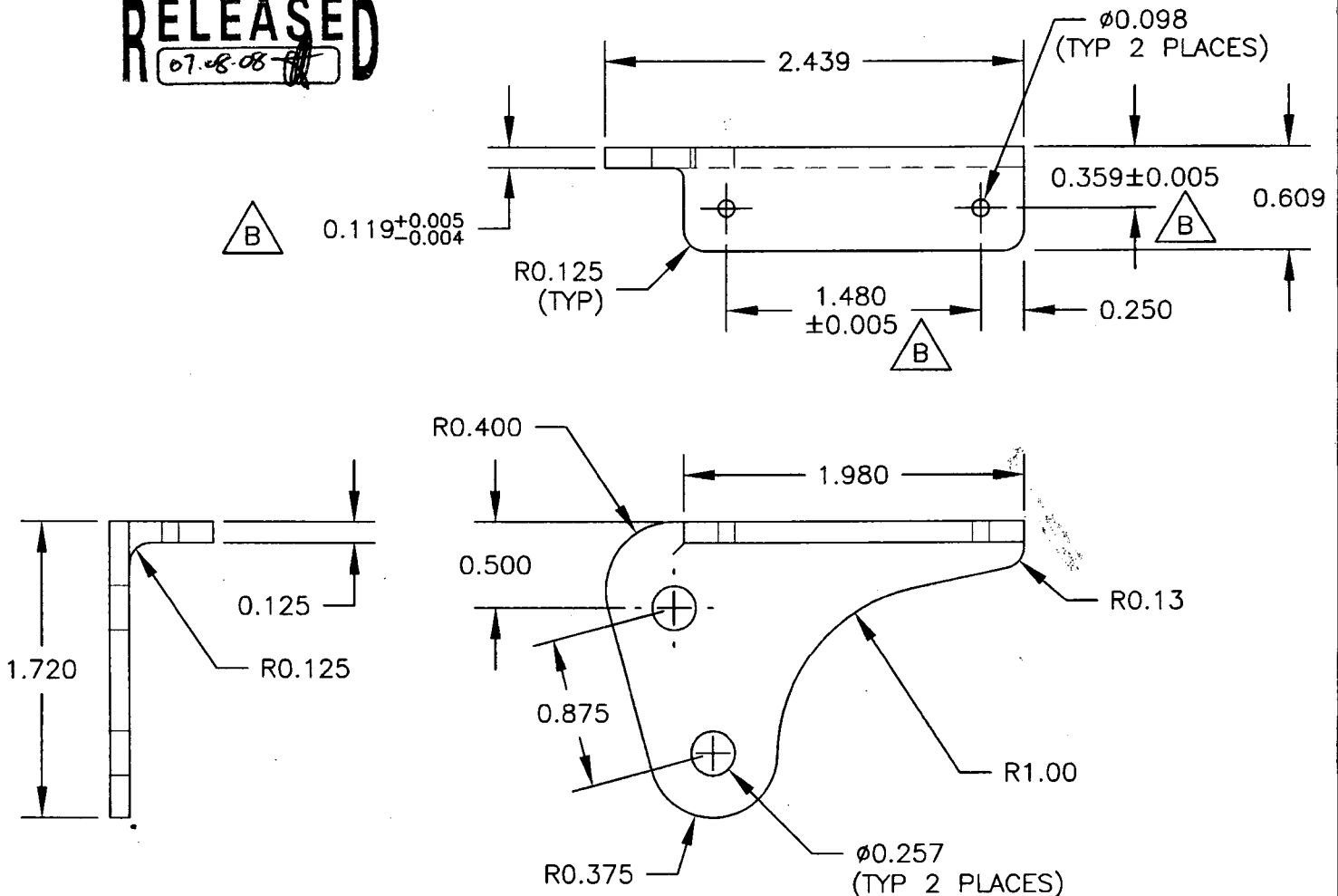
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DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08



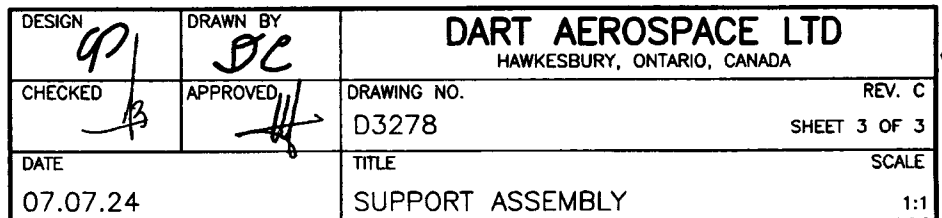
D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

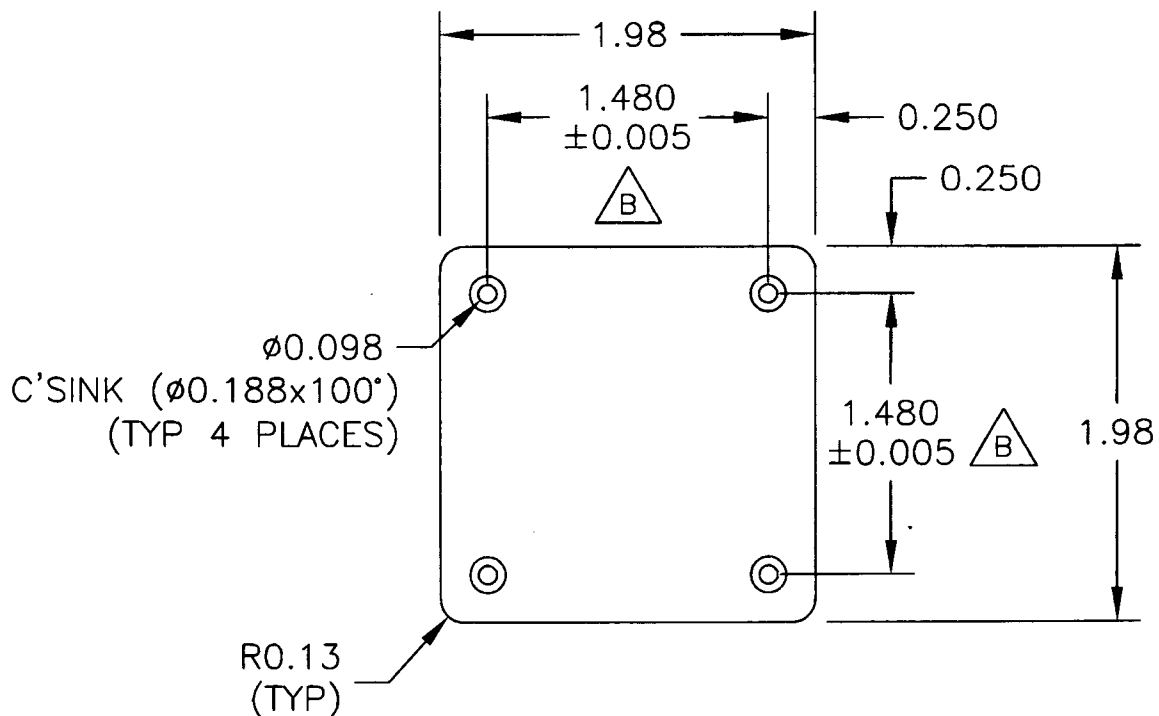
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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RELEASED
07-08-08



- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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